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D119-646-253
Job Sheet 201531



Part No: D119-646-253

Job Qty: 4 pcs

Part Name: AW119 Heavy-Duty Wearplates, Float Skid Compatible - Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/7/19

Job Tracking No:

Due Date: 10/14/19

Type: SOLD

Created By: Marie Lajeunesse

Description:

Note: DWG REV D IPP RevA: New issue DD verified by:EC IPP Rev:B 12.09.12 as per ECN12-644 DD verf:JLM IPP
REV:B 16.03.31 AS PER chg003 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs	10/14/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		DAS
							Packaging 1 - 5		28
							Packaging 1 - 6		9-89
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S246163



Part: D119-646-253

Job No: 201531

Serial No/Batch: S246163

Revision:

Inspector:

Exp Date:

Instructions: FAA STC SR02024SE 18/10/17, T6 STC LoA P.

120 QC 4	4 pcs	10/14/19	0.00 0.00	Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
130 Packaging 3-1 - Stock - B4B 4 pcs		10/14/19	0.00 0.00	QC 4 - 74	88-8 JAN 10 2020
				QC 4 - 75	82
				QC 4 - 78	DAS
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
135 DC - 1 - B4B	4 pcs	10/14/19	0.00 0.00	Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
140 QC 21 - FG	4 pcs	10/14/19	0.00 0.00	Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	78
				Packaging 3 - 26 - B4B	9-89 JAN 10 2020
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	DAS
Part Op 110 - (Pick Kit) Descriptions: 120 - (QC4- 100% inspect kits for completeness)				DC - 1 - B4B	21 JAN 10 2020
				DC - 2 - B4B	9-89
				QC 21 - FG - 21	
				QC 21 - FG - 70	DAS
				QC 21 - SA - 53	21 JAN 10 2020

FG2813,

130 - Identify and pack for shipping as per PPP D119-646-253 Location: _____ PPP rev: _____
135 - DC (Document Control) Photocopy bluefile & type labels per PPP D119-646-253 CHG003 4
140 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C46A	Bolt	32 Ea (8 ea)	110-Packaging 1 - Pick Kit	S230767 / 230765
AN3C5A	Bolt	40 Ea (10 ea)	110-Packaging 1 - Pick Kit	S237825
D3847-1 FPO01	Wearpad	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	S211374
D3847-11 FPO01	Wearpad	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	S212298
D3849-045	Aft Heavy-Duty Wearplate, Float Skid Compatible	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	S245859
D3849-047	Fwd Heavy-Duty Wearplate, Float Skid Compatible	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	S245864
D3904-1 FPO01	Washer	64 pcs (16 ea)	110-Packaging 1 - Pick Kit	S221558
MS21043-3	Nut	32 Ea (8 ea)	110-Packaging 1 - Pick Kit	S24N52
NAS1149C0332R	Washer (AN960C10L)	40 Ea (10 ea)	110-Packaging 1 - Pick Kit	S225629

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	AN3C46A	32	210	0
	AN3C5A	40	746	0
	D3847-1	4	21	0
	D3847-11	4	13	0
	D3849-045	4	1	0
	D3849-047	4	1	0
	D3904-1	64	100	0
	MS21043-3	32	958	0
	NAS1149C0332R	40	4,028	0

Part Specifications

Specifications could not be found.

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*
A 3411-3 (24) Added
AN3C50A (4) Added
AN3C46A was 8
is 4

5238023

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only _____

Job: _____

Part No. _____

DISPOSITION

Rework

Scrap

Use-as-is

DEPARTMENT/PROCESS

Skid-tube

Cross tube

Eng. (Non-AW)

Engineering

Machining

Small Fab

Prod. Eng. Coord.

Water Jet

Large Fab

Finishing

Rec/Store/Packaging

Supplier

Quality

Date :

Sequence #:

QTY Affected :

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator

Manufacturing Process

Equip/Tooling

Handling/Preservation

Material

Product Improvement

Process Improvement

Human Factors

FAULT CATEGORY

Pressure/Forced

Bending

Crushing

Cracks

Crimp/Kink/Ripple/Wave/Twist

Marks/Chatter

Mislabeled

Other/Details:

Contamination

Misaligned/off center

BOM/Route

Broken/Damage/Defect

Incomplete/Unclear Instructions

Drill Holes

Fit/Function

Power Loss/Surge

Folio/Program

Grain Direction

Weld

Wrong Stock Pulled

Out of Sequence

Off-set/Set-up

Positioned Wrong

Outside Tolerance

Drawing

Finish

Part Lost/Missing

Misread

ITEM	QTY -013	QTY -014	QTY -113	QTY -114	QTY -213	QTY -214	P/N	DESCRIPTION
*120							MS21250-05048	BOLT
*121							NAS1149C0532R	WASHER
*122							D3672-7	WASHER
*123							MS21043-5	NUT
*124							D5449-1	FLOAT SADDLE WASHER

* SUPPLIED WITH DART CROSSTUBES

() ITEMS IN BRACKETS ARE REF. ONLY AND DO NOT NEED TO BE INCLUDED WITH KIT AS THEY ARE ALREADY
INSTALLED ON SKIDTUBE

5.4 Float Skidtube Replacements

ITEM	QTY -043	QTY -053	QTY -143	QTY -153	QTY -243	QTY -253	P/N	DESCRIPTION
	X						D119-646-043	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS
		X					D119-646-053	WEARPAD KIT, FLOAT SKIDTUBE
			X				D119-646-143	REPLACEMENT FLOAT SKIDTUBE WITH WEARPADS AND FULL LENGTH WEARPLATES
				X			D119-646-153	WEARPLATE KIT, FLOAT SKIDTUBE
					X		D119-646-243	REPLACEMENT FLOAT SKIDTUBE WITH TRAINING WEARPLATES
						X	D119-646-253	TRAINING WEARPLATE KIT, FLOAT SKIDTUBE
1	1						D3905-041	FLOAT SKIDTUBE ASSY, WITH WEARPADS
20			1				D3905-043	FLOAT SKIDTUBE ASSY, WITH WEARPADS AND FULL LENGTH WEARPLATES
26			(1)	1			D3847-043	FWD WEARPLATE ASSY
27			(1)	1			D3847-045	CENTER WEARPLATE ASSY
28			(1)	1			D3847-049	AFT WEARPLATE ASSY
29	(8)	8	(8)	8			D3847-1	WEARPAD
30	(1)	1	(1)	1			D3847-11	WEARPAD
31	(36)	36	(42)	42			AN3C5A	BOLT
32	(36)	36	(42)	42			NAS1149C0332R	WASHER
40					1		D3905-045	FLOAT SKIDTUBE ASSY, WITH TRAINING WEARPLATES
44					(1)	1	D3847-047	FWD TRAINING WEARPLATE ASSY
45					(1)	1	D3847-045	AFT TRAINING WEARPLATE ASSY
48					(1)	1	D3847-1	WEARPAD
49					(1)	1	D3847-11	WEARPAD
51a					(16)	16	D3905-1	WASHER
51b					(24)	24	D3905-3	WASHER
52					(4)	4	AN3C48A	BOLT
53					(8)	8	MS21043-3	NUT
54a					(10)	10	AN3C5A	BOLT
54b					(4)	4	AN3C50A	BOLT
55					(10)	10	NAS1149C0332R	WASHER

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INSTALLED ON SKIDTUBE

Revision Record

Revision No.	Issue Date	Description
A	09.04.07	New Issue
B	09.06.29	Update 3.10b to clarify fwd float installation. Add Item 84 to Detail C. Update Detail E to shown item 104. Update Detail G to shown float installed underneath wearplate. Correct typos in Part List. Update Weights in Section 5.0
C	13.08.16	Add torque values in Section 3.3 & 3.4, ref. CIR13-17. Incorporate DSI 9526 and DSI 9630. Remove Gaskets. Update Figures 2 thru 7. Update Detail C
D	17.02.21	Updated crosstube compatibility reference. Updated Agusta crosstube part numbers. Added instructions to modify D119-646-041/-141 to D119-646-241 skidtubes, Section 3.12 . Revised Detail A to show OEM and Dart crosstube installations Corrected part numbers in Section 5.0, Weight and Balance. Added Dart D119-796-XXX Installation hardware reference.
E	18.08.17	Added D119-646-051/-053 Wearpad Kits, Ref. CIR17-108. Incorporated DSI 9734, Ref. NCR17-6586. Added instructions to modify D119-646-043/-143 to D119-646-243, Ref NCR18-6905. Restructured and updated Parts Lists. Renumbered Sections.